


[illegible]


1. BREAK ALL SHARP CORNERS (.015/.03).

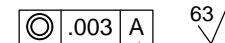
| | | |
|---|-----------------------------|---|
|  RED BARN MACHINE | | |
| TITLE RBST2400 SERIES TRI-ROLLER SWAGING TOOL; LOCATING PIN | | |
| DWG NO. | TOOL# (see chart)-15 | REV 2 |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5° | | DRAWN BY: PERRITT APPROVED _____ HEAT TREAT _____ FINISH SPEC BLACK OXIDE |
| UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | | USED ON BEARING SEE Pg. 1 |
| SCALE NTS | DATE 4-24-08 | SHEET 9 of 9 |

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|--|---------------------|--|-----------------|
|  RED BARN MACHINE | | | |
| TITLE RBST2400 SERIES TRI-ROLLER SWAGING TOOL; SECONDARY SEAT | | | |
| DWG NO. TOOL# (see chart)-13 | | | REV 2 |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5° | | DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH BLACK OXIDE SPEC USED ON BEARING SEE Pg. 1 | |
| UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 X45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | | | |
| SCALE NTS | DATE 4-24-08 | SHEET 8 | of 9 |

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|--|---------------------|--|-----------------|
|  RED BARN MACHINE | | | |
| TITLE RBST 2100 SERIES TRI-ROLLER SWAGING TOOL; PRIMARY SEAT | | | |
| DWG NO. TOOL# (see chart)-11 | | | REV 2 |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5° | | DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH BLACK OXIDE SPEC | |
| UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | | USED ON BEARING SEE Pg. 1 | |
| SCALE NTS | DATE 4-24-08 | SHEET 7 | of 9 |




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|  RED BARN MACHINE | |
| TITLE RBST2400 SERIES TRI-ROLLER SWAGING TOOL; PIN | |
| DWG NO. | REV 2 |
| TOOL# (see chart)-9 | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5° | DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1 |
| UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | |
| SCALE NTS | DATE 4-24-08 SHEET 6 of 9 |

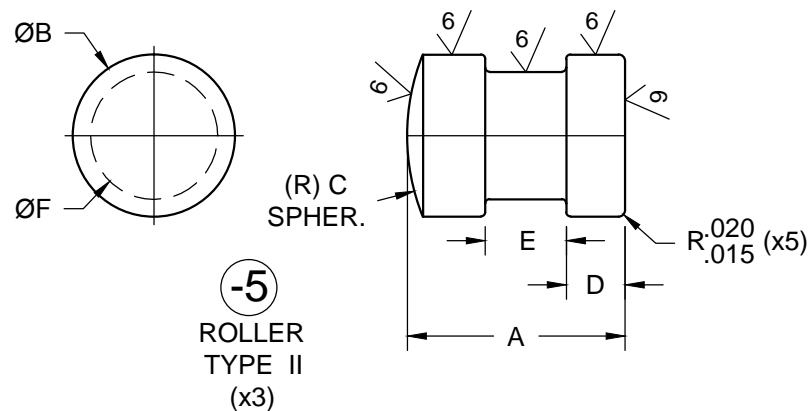



GUIDE

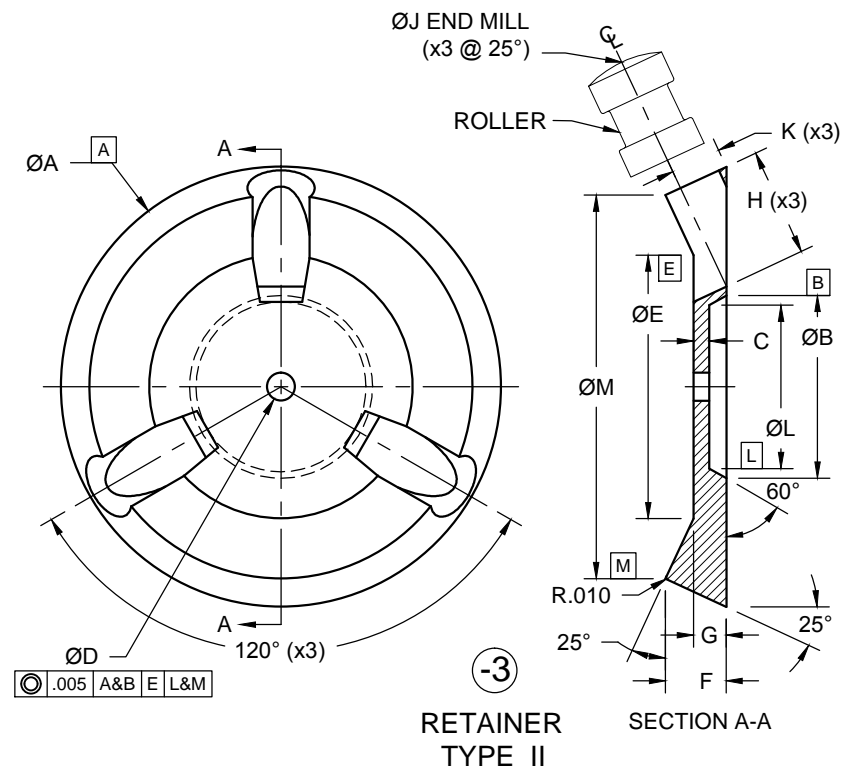
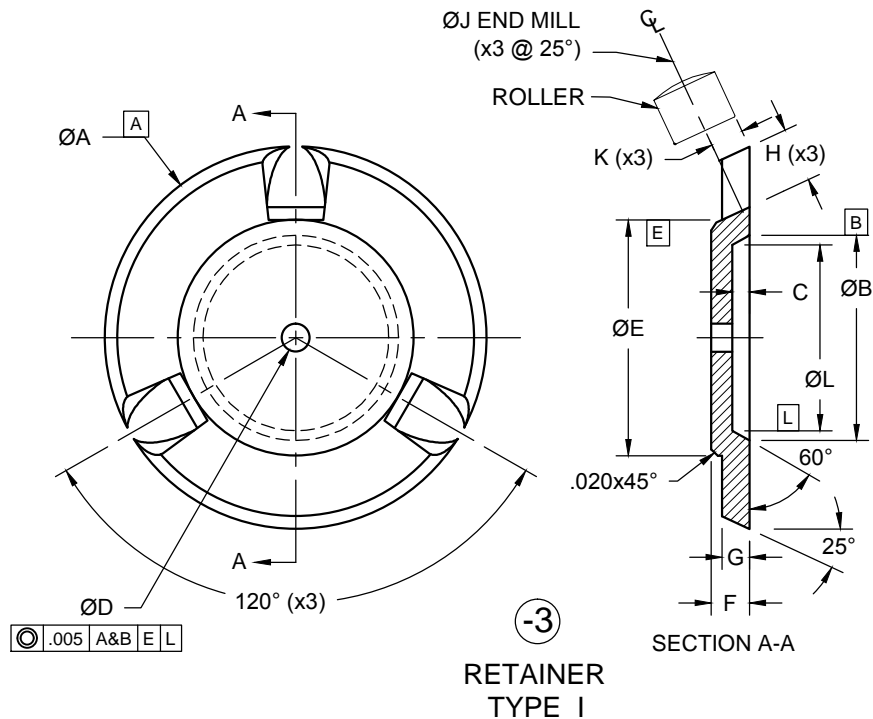
NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).

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|  RED BARN MACHINE | |
| TITLE RBST2400 SERIES TRI-ROLLER SWAGING TOOL; GUIDE | |
| DWG NO. | REV 2 |
| TOOL# (see chart)-7 | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5° | DRAWN BY: PERRITT <hr/> APPROVED <hr/> HEAT TREAT <hr/> FINISH <hr/> SPEC |
| UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 ± 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | USED ON BEARING <hr/> SEE Pg. 1 <hr/> |
| SCALE NTS | DATE 4-24-08 |
| SHEET 5 of 9 | |

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|  RED BARN MACHINE | |
| TITLE RBST2400 SERIES TRI-ROLLER SWAGING TOOL; ROLLER (QTY. 3) | |
| DWG NO. T.OOL# (see chart)-5 | REV 2 |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5° | DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC |
| UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | USED ON BEARING SEE Pg. 1 |
| SCALE NTS | DATE 4-24-08 SHEET 4 of 9 |



- NOTES
- BREAK ALL SHARP CORNERS (.015/.03).

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| RED BARN MACHINE | |
| TITLE RBST2400 SERIES TRI-ROLLER SWAGING TOOL; RETAINER | |
| DWG NO. TOOL# (see chart)-3 | REV 2 |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1 | DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC USED ON BEARING SEE Pg. 1 |
| UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | |
| SCALE NTS | DATE 4-24-08 SHEET 3 of 9 |

| REVISIONS | | | | |
|-----------|--|---------|---------|----------|
| REV | DESCRIPTION | DATE | INITIAL | APPROVED |
| 2 | -1 CH'D TOL. (H) WAS +/--.002 IS +/--.005. | 6/17/13 | BIM | GE |



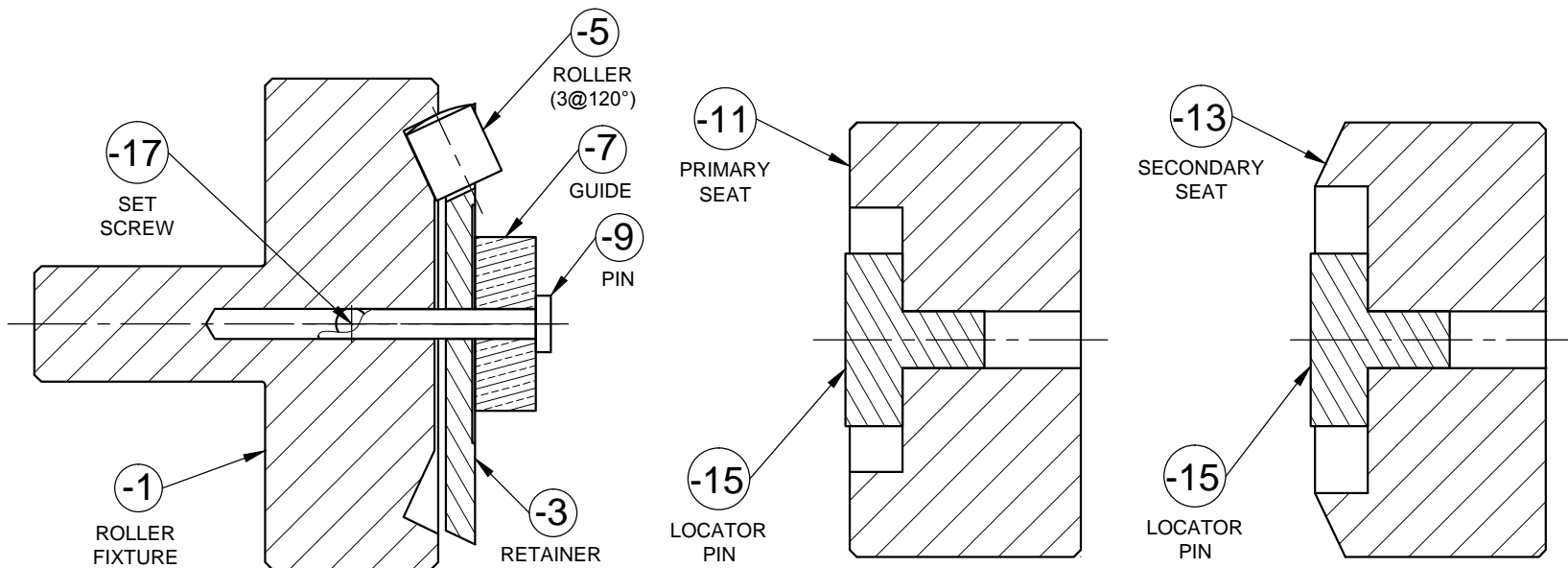
 RED BARN MACHINE

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| DWG NO. | TOOL# (see chart)-1 | REV 2 |
|---------|---------------------|----------|

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| SCALE | NTS | DATE | 4-24-08 | SHEET | 2 of 9 |
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| REVISIONS | | | | |
|-----------|---|----------|---------|----------|
| REV | DESCRIPTION | DATE | INITIAL | APPROVED |
| 1 | CHANGED -5 ROLLER RADUIS FROM .005 - .010, TO .015 - .020; AND -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. ALSO CHANGED -7 SLEEVE TO -7 GUIDE. | 7/7/08 | WP | DW |
| 1A | CH'D T/N'S FROM KST. | 11/20/09 | RJC | |
| 2 | -1 CH'D TOL. (H) WAS +/- .002 IS +/- .005. | 6/17/13 | BIM | GE |



| BEARINGS & TOOLS COVERED | |
|--------------------------|----------|
| BEARING # | TOOL # |
| 230-330-509-101 | RBST2417 |
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NOTES


1. -5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
2. -5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
3. FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.

| ASSY QTY | B/O | PART # | UNIT QTY | DESCRIPTION | B/O INFORMATION OR SPECIFICATIONS | Pg. |
|----------|-----|--------|----------|-----------------------|-----------------------------------|-----|
| | | -1 | 1 | ROLLER FIXTURE | SEE CHART | 2 |
| | | -3 | 1 | RETAINER | SEE CHART | 3 |
| | | -5 | 3 | ROLLER | SEE CHART | 4 |
| | | -7 | 1 | GUIDE | SEE CHART | 5 |
| | | -9 | 1 | PIN | SEE CHART | 6 |
| | | -11 | 1 | PRIMARY SEAT | SEE CHART | 7 |
| | | -13 | 0 or 1 | SECONDARY SEAT | SEE CHART | 8 |
| | | -15 | 1 or 2 | LOCATING PIN | SEE CHART | 9 |
| B/O | | -17 | 1 | SOCKET HEAD SET SCREW | #8-32 x 1/4 | N/S |

RED BARN MACHINE

| | | |
|---|-----------------|---|
| TITLE RBST2400 SERIES TRI-ROLLER SWAGING TOOLS | | REV 2 |
| DWG NO. TOOL # (SEE CHART ABOVE) | | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 | | DRAWN BY: PERRITT APPROVED HEAT TREAT LISTED PER ITEM FINISH LISTED PER ITEM SPEC USED ON BEARING SEE ABOVE |
| UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | | |
| SCALE NTS | DATE 4-24-08 | SHEET 1 of 9 |

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| | | | |
|--|-----|---|---------|
|  RED BARN MACHINE | | | |
| TITLE | | | |
| DWG NO. | | | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5° | | DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC | |
| UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | | USED ON MODEL | |
| SCALE | NTS | DATE | 8-15-07 |
| | | SHEET | 1 of 1 |

NOT APPROVED FOR PRODUCTION

| REVISIONS | | | |
|-----------|-------------|------|----------|
| REV | DESCRIPTION | DATE | APPROVED |
| | | | |

| PART # | QTY | DESCRIPTION |
|--------|-----|-------------|
| -1 | 1 | -- |
| | | |

| | | | |
|---|---|--------------|--------------|
| DRAWN BY: PERRITT | <div>RB</div> RED BARN MACHINE | | |
| CHECKED | TITLE | | |
| HEAT TREAT FINISH SPEC | TITLE | | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 | FRACTIONS ± 1/32 ANGLES ± .5° | | REV. |
| USED ON MODEL ? | DWG NO. PART # | | |
| | SCALE NTS | DATE 1-28-06 | SHEET 1 of 1 |
| | UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | | |